

FIG. 1

10

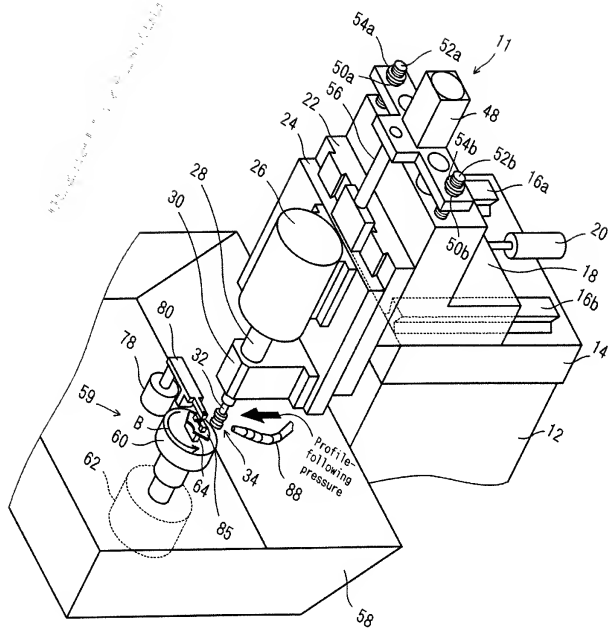


FIG. 2

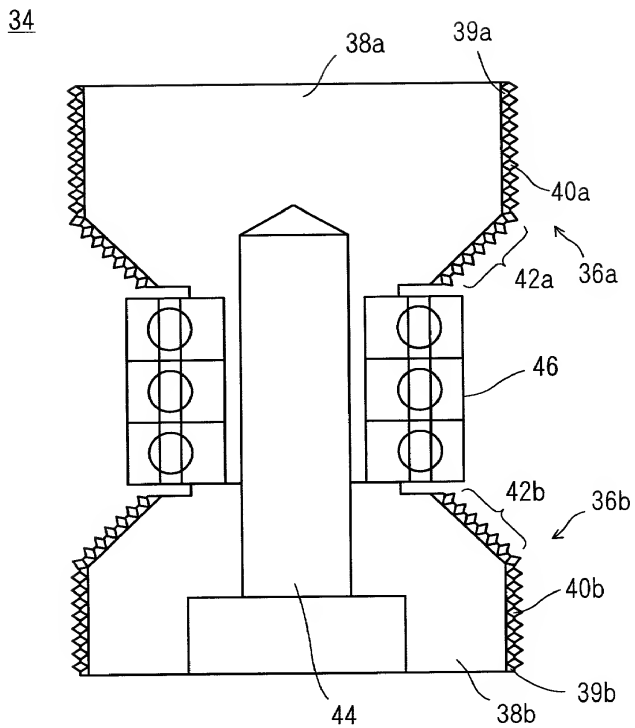


FIG. 3

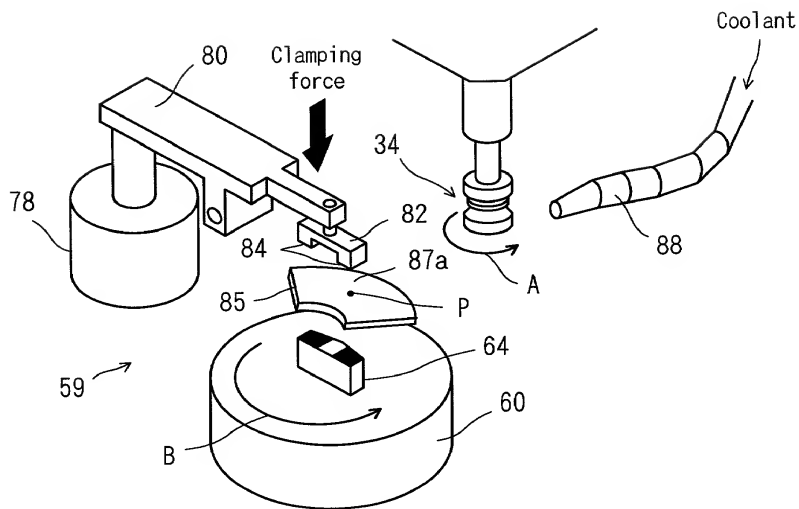


FIG. 4A

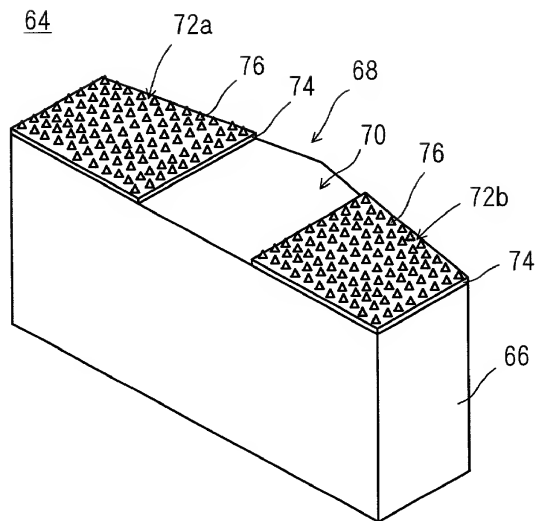
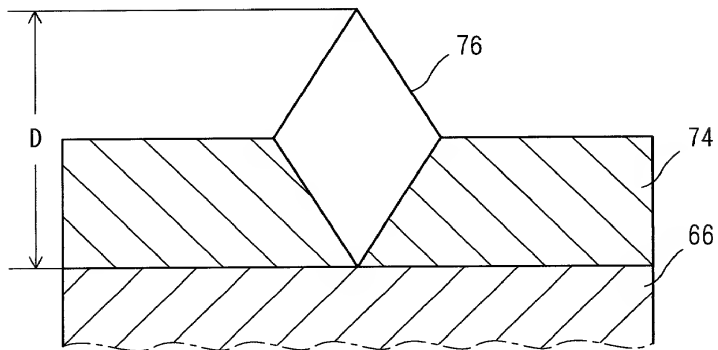


FIG. 4B



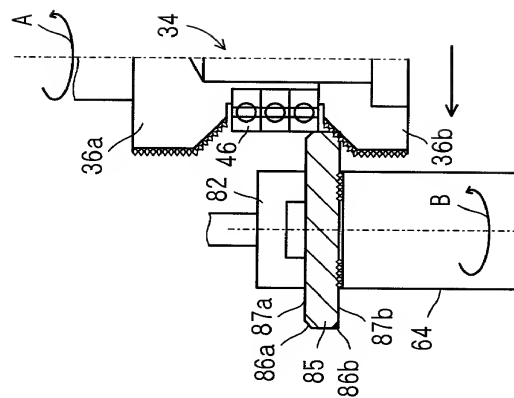
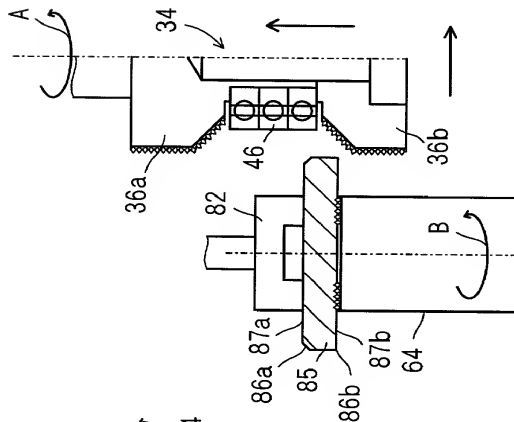
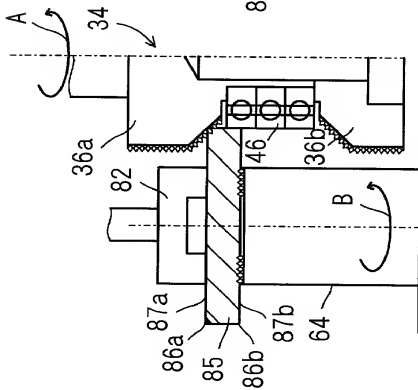
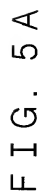


FIG. 6

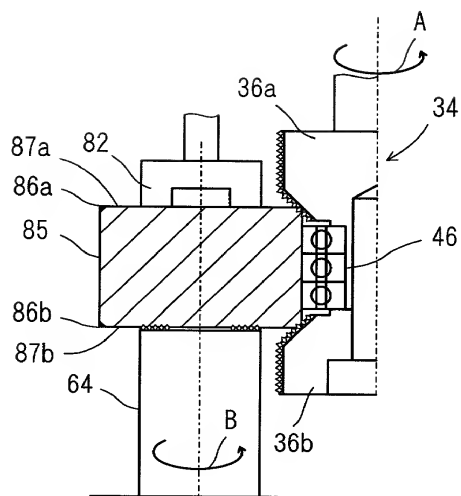


FIG. 7 A

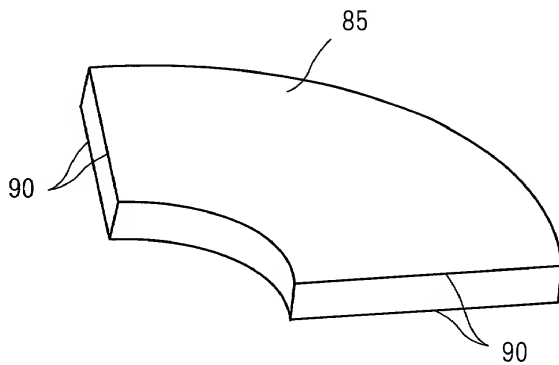


FIG. 7 B

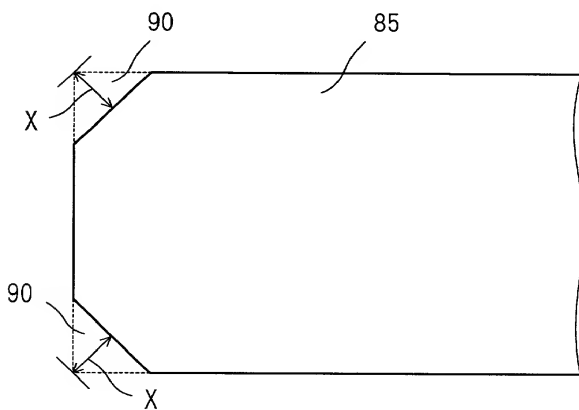


FIG. 8A

Relationship between Grinding Stone  
Rotating Speed and Chipping

Grinding stone rotating speed (rpm)	500	1000	2000	3000	4000	5000	6000	7000
Grinding stone circumferential speed (m/min)	31.4	62.8	125.6	188.4	251.2	314	376.8	439.6
Number of chippings (Diameter $\geq 1\text{mm}$ )	20	15	10	8	5	10	35	Seizure

FIG. 8B

